

Work Order ID 70893

Thursday, June 16, 2011 2:32:37 PM

PROTOTYPE



Page 1

Item ID: D4007-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Top Support Bracket

Start Date: 6/16/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4007	A								
100		0.00							
Purchasing	Memo	0.00							
Purchasing	Issue P/O:								
2024. 063	Purchase part as per Dwg D4007								
	Possible Supplier: GRI								
	Material release note required								
101		0.00							
Waterjet	Memo	0.00							
FLOW CNC Waterjet	cut as per drwg D4007 Rev.A								
102		0.00							
QC	QC2- Inspect parts off machine FAI/FAIB	0.00							
Quality Control	Memo	0.00							

SCRAP

Scrap
Scrap

B11-6-22

4

B11-6-22

Work Order ID 70893

Thursday, June 16, 2011 2:32:37 PM



Page 2

Item ID: D4007-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Top Support Bracket

Start Date: 6/16/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
103 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00							
130 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							
140 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							

Work Order ID 70893

Thursday, June 16, 2011 2:32:37 PM



Page 3

Item ID: D4007-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Top Support Bracket

Start Date: 6/16/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: _____	0.00							
	Packaging								
	Memo	0.00							
	Packaging								
160	QC21- Final Inspection - Work Order Release	0.00							
	QC								
	Memo	0.00							
	Quality Control								

will 75

Picklist Print

Page 1

Thursday, June 16, 2011 2:32:34 PM

Work Order ID: 70893



Parent Item: D4007-1



Parent Item Name: Top Support Bracket

Start Date: 6/16/2011

Required Date: 6/22/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev A 09.12.18 new Issue Prelim EC verified: DD IPP Rev:B
10.05.03 as per ECN10-562 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M2024T3S.063		Purchased	No				sf	269.5700		0.35			
--------------	--	-----------	----	--	--	--	----	----------	--	------	--	--	--



B11-6-22

2024-T3 .063 sheet

Location

Loc Qty

Loc Code

MAT022

269.57

113867

0.19

117018

26.88

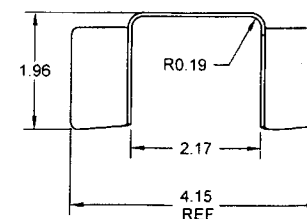
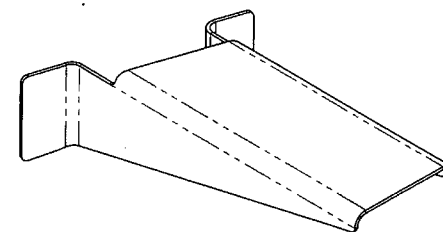
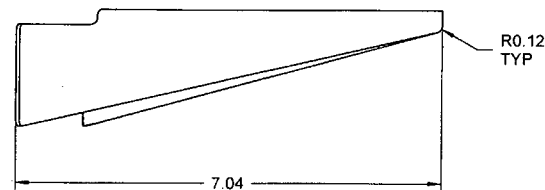
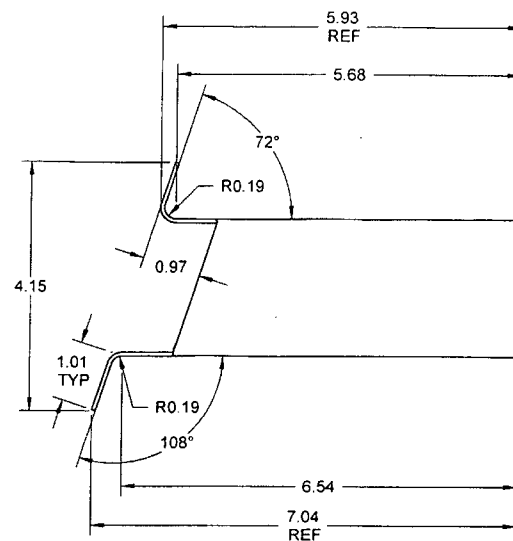
117392

242.5

117392

(4)

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4007-1	JCA-M47-2-02



D4007-1 TOP SUPPORT BRACKET

NOTES:

- 1) MATERIAL: MADE FROM D4007-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4007-1" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.17 lbs

RELEASED
2010-05-05

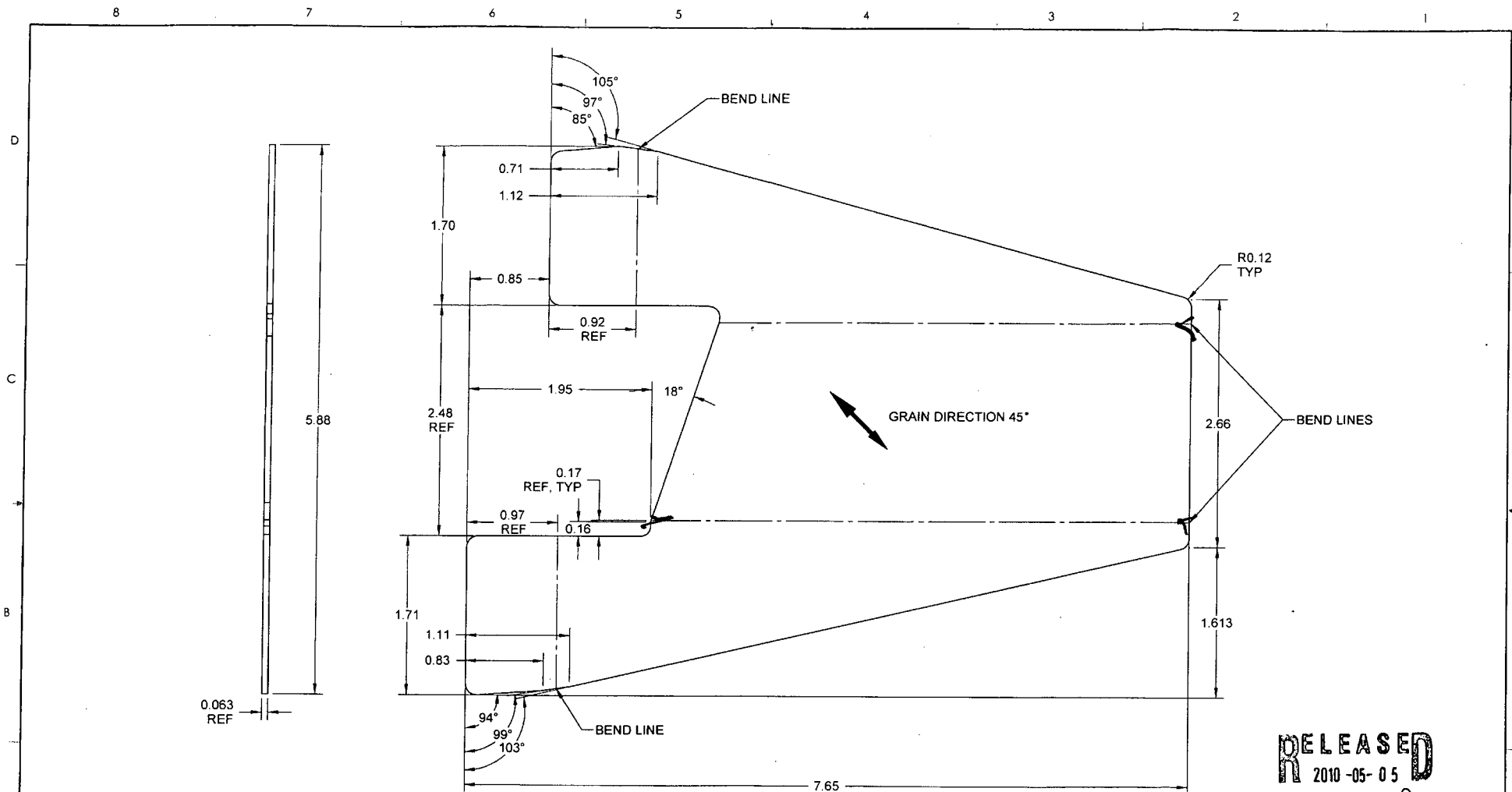
REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE		10.02.05
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.02.05		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4007** REV. A
SHEET 1 OF 5

TITLE **SUPPORT** SCALE NTS

COPYRIGHT © 2010 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD



NOTES:

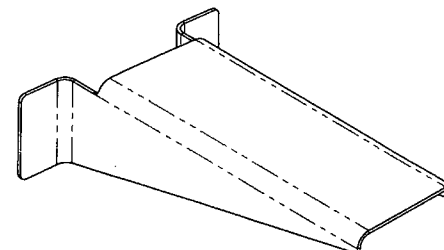
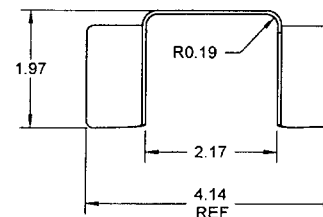
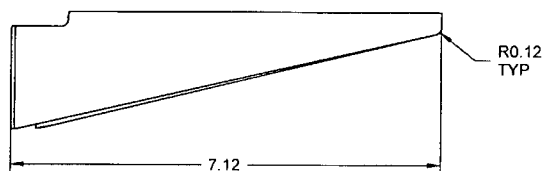
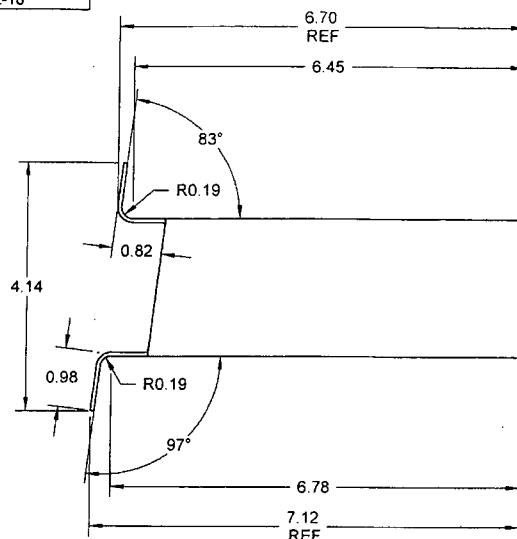
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.17 lbs

D4007-1F FLAT PATTERN

70863

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4007	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SUPPORT	NTS
DATE	10.02.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4007-3	JCA-M47-2-18



D4007-3 TOP SUPPORT BRACKET

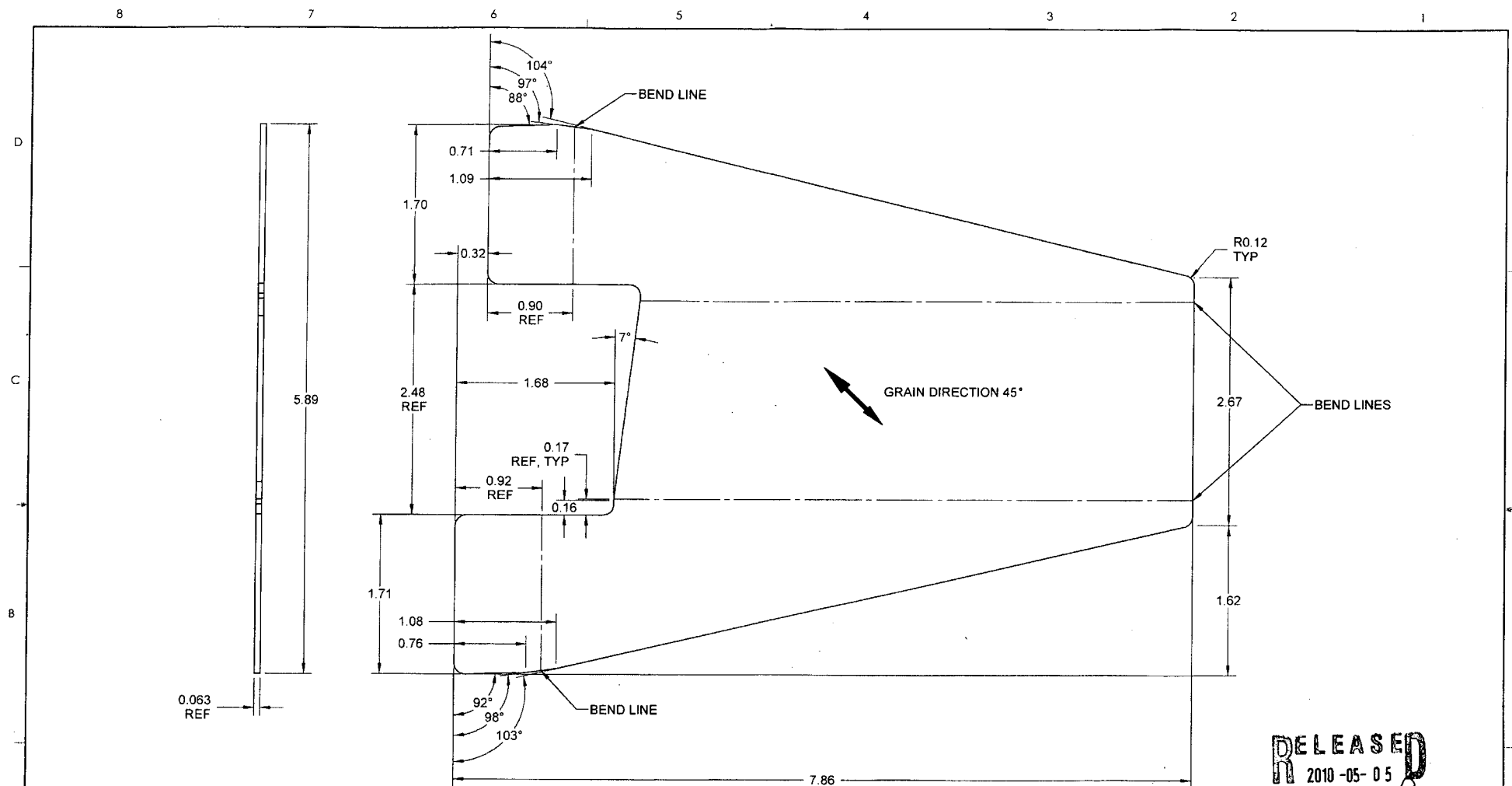
NOTES:

- 1) MATERIAL: MADE FROM D4007-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4007-3" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.19 lbs

70843

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4007	REV. A
MFG. APPR.			SHEET 3 OF 5
APPROVED		TITLE SUPPORT	SCALE
DE APPR.			NTS
DATE	10.02.05	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

RELEASED
2010-05-05
MP



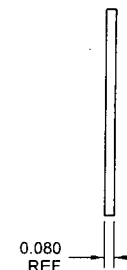
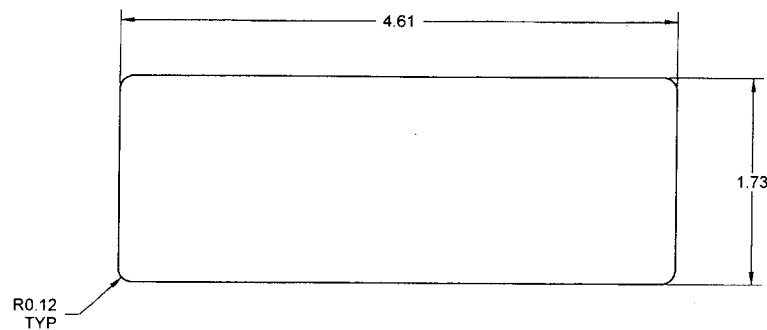
NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.19 lbs

D4007-3F FLAT PATTERN

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO. D4007	REV. A
CHECKED		SHEET 4 OF 5	
MFG. APPR.		TITLE SUPPORT	SCALE NTS
APPROVED		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DE APPR.		DATE 10.02.05	

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4007-5	JCA-M47-2-24



D4007-5 PACKER

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.080 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.080
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4007-5" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.06 lbs

RELEASED
2010-05-05
MP

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4007	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SUPPORT	NTS
DATE	10.02.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. NOISE SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			